

Work Order ID 141765

Thursday, February 11, 2016 10:23:47 AM

141765

Page 1

Item ID: D3188-6 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacepod Body
 Start Date: 2/11/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/18/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: ML3 Date: FEB 11 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3188	Rev G								
100	QC6- Inspect dimensions to drawing	0.00							DAS 16 9-89
100									
QC	Memo	0.00							16-02-12
Quality Control	Check for void spot and pins.								
110	Identify as per dwg & Stock Location: <u>CA2</u>	0.00							DAS 02 9-89
110									
Packaging	Memo	0.00							16-06-16
Packaging	Location : CA2								
	<u>W/O 141762</u>								
120	QC21- Final Inspection - Work Order Release	0.00							
120									
QC	Memo	0.00							DAS 21 9-89
Quality Control									AUG 2 4 2016

DAS
21
9-89
AUG 2 3 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

Picklist Print

Thursday, February 11, 2016 10:23:51 AM

Page 1

Work Order ID: 141765

141765

Parent Item: D3188-6

D3188-6

Parent Item Name: Spacepod Body

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-02-05 New Issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3188-2P		Purchased	No			100	Each	0.0000	1	1			
D3188-2P									**				
Spacepod Body													

DAS
13
9-89

AUG 23 2016

B141768

DAS
02
9-89

16-08-16

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE 'S' GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING 'E' GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, 'E' GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

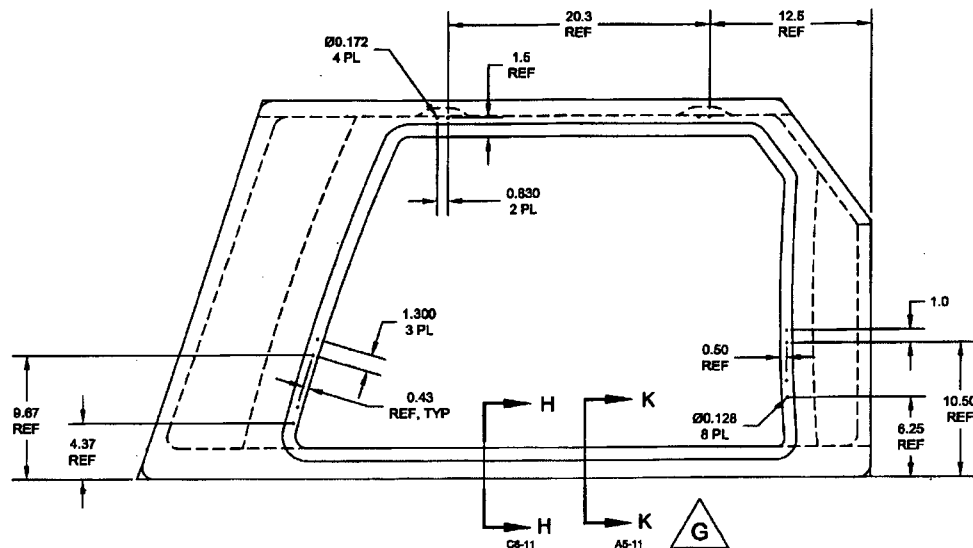
9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

10) POT INSERTS PER QSI 006 SECTION 4.16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 141765 M03
1602-11

RELEASED
2014-07-28

G	ADD SECTION K-K/L-L: INSERT INSTALLATION TO SHEET 11 (ZN A5-11)	DB	14.06.20
F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS: ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0800-XXX LABELS	LE	08.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	08.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	14.06.20	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

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2014-07-28

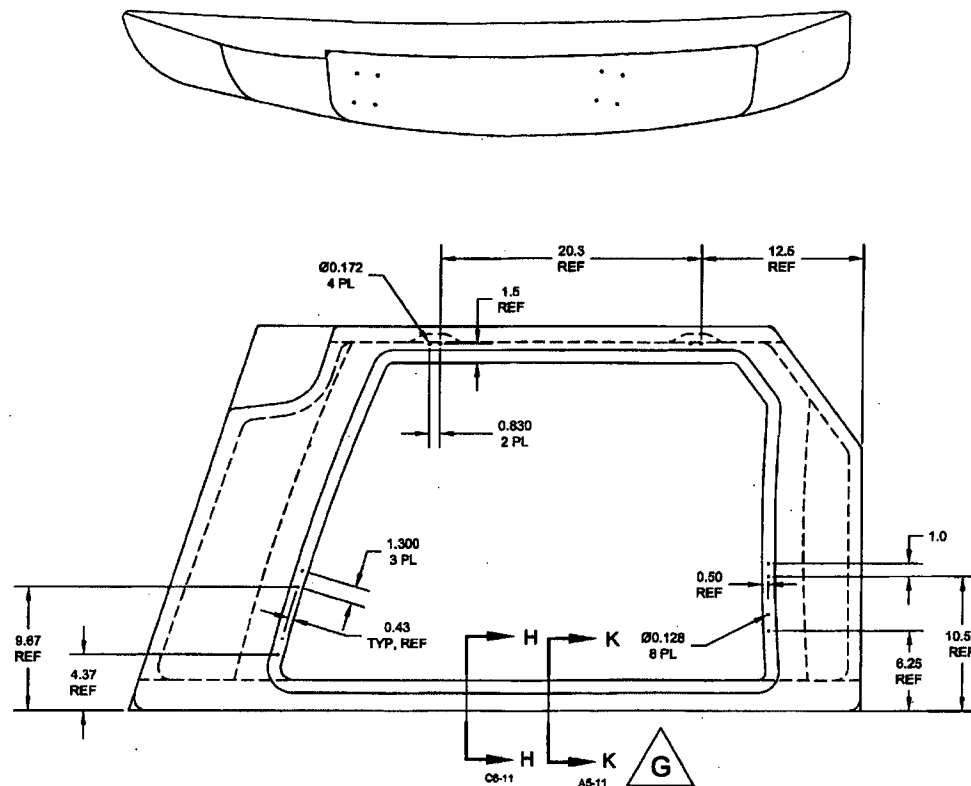
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 2 OF 11
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV.
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 3 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NT
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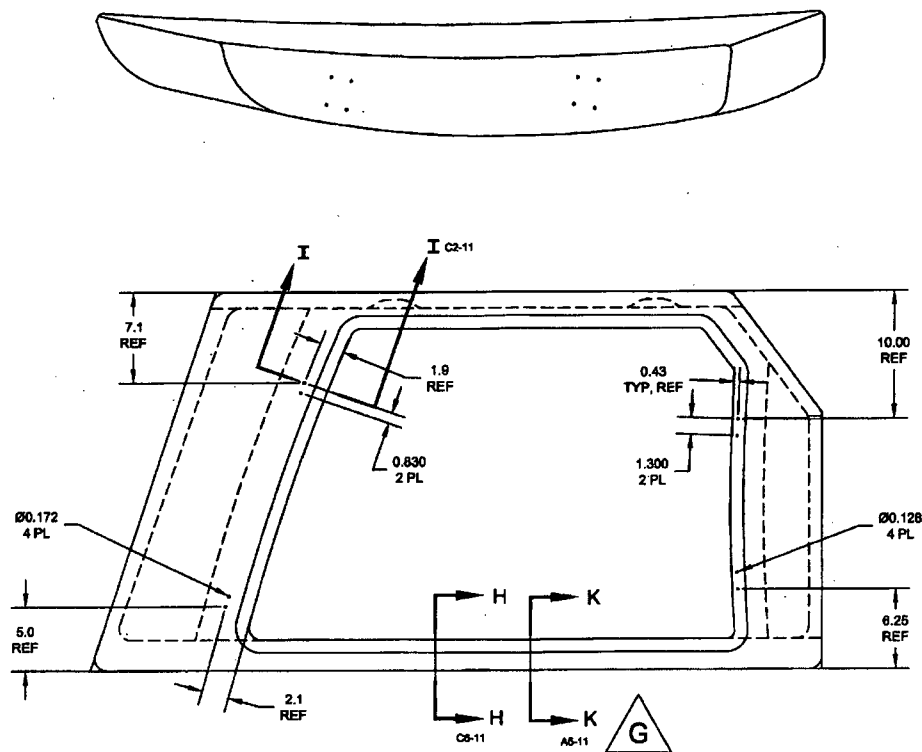
D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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MFG. APPR.		D3188	SHEET 4 OF 11
APPROVED		TITLE	SCALE
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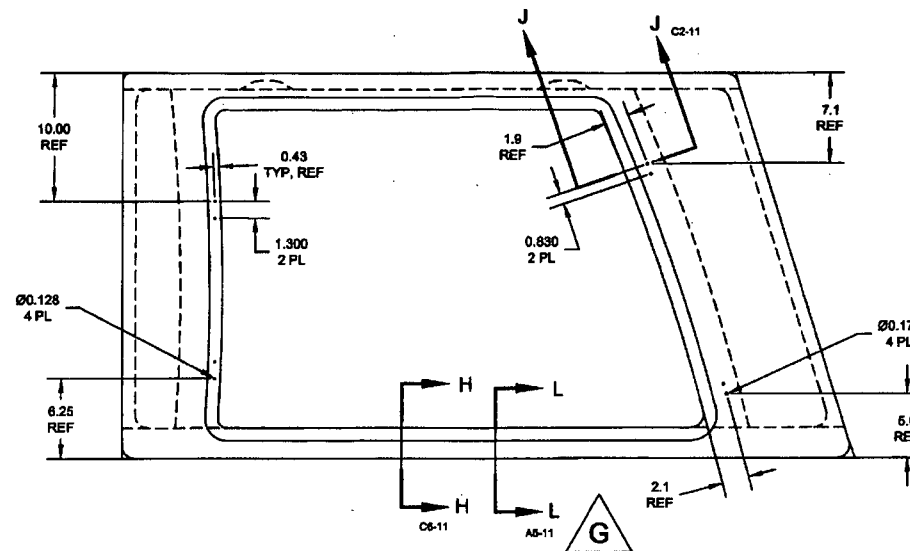
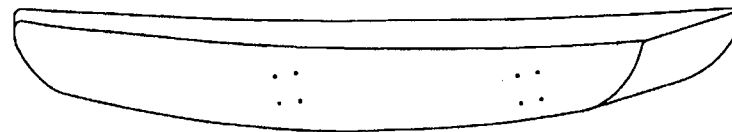
D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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MFG. APPR.		D3188	SHEET 5 OF 11
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DE APPR.		SPACEPOD BODY	NTS
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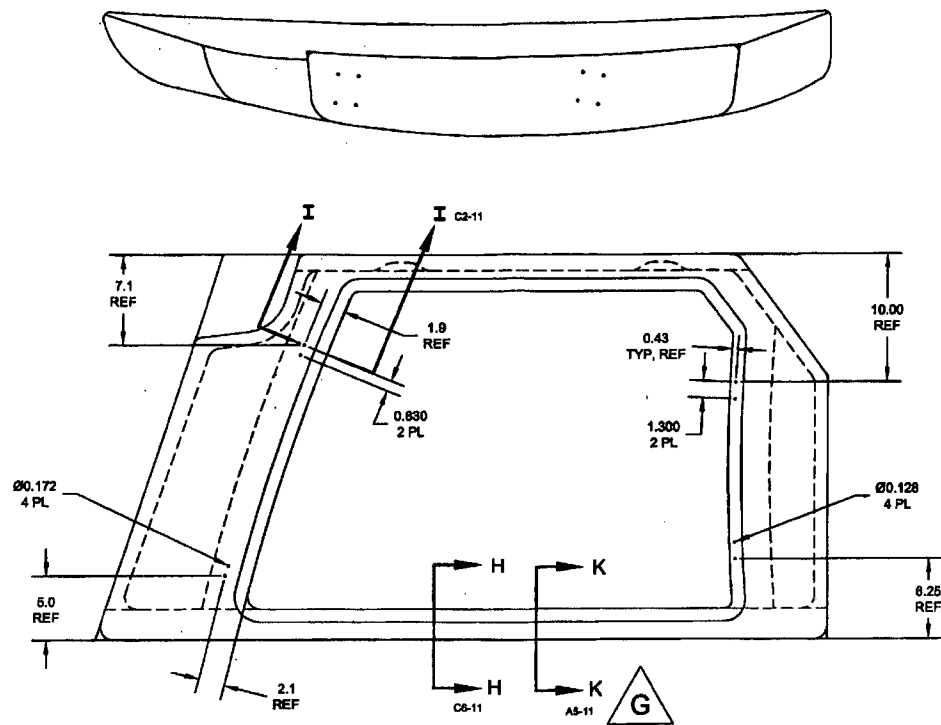


D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

RELEASED
2014-07-28

- NOTES:**
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3188-4 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
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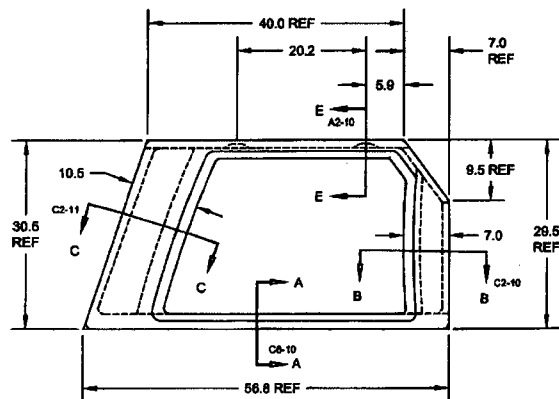
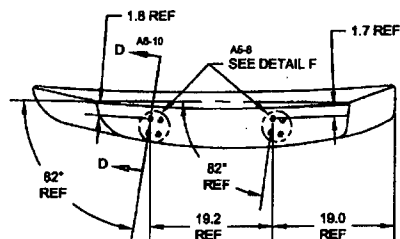


D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

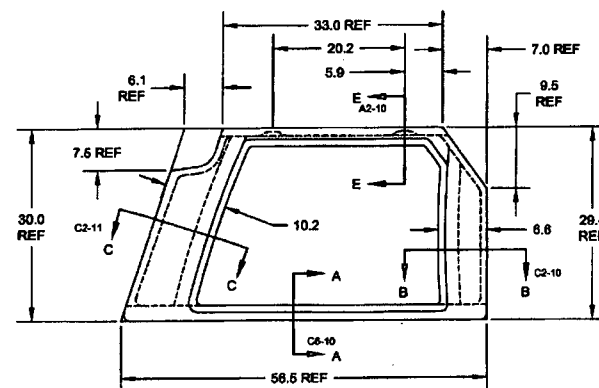
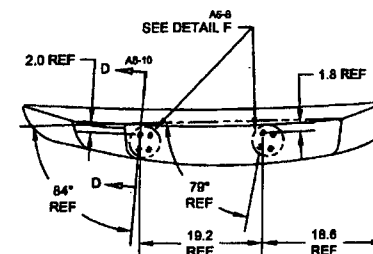
RELEASED
2014-07-28
JWW

- NOTE:**
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

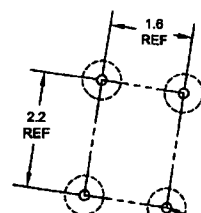
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
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D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY



DETAIL F

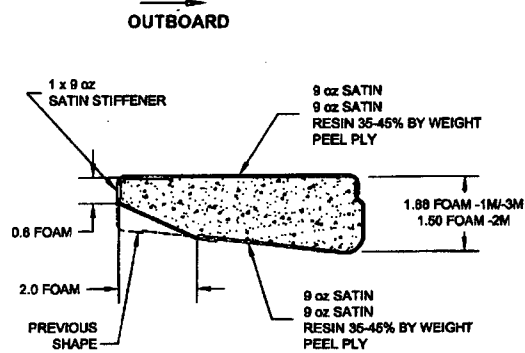
INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A5-10

RELEASED
2014-07-28

D3188-1M/-3M NOTES:

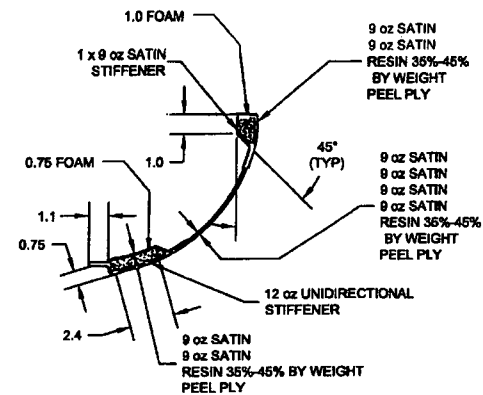
- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 8 OF 11
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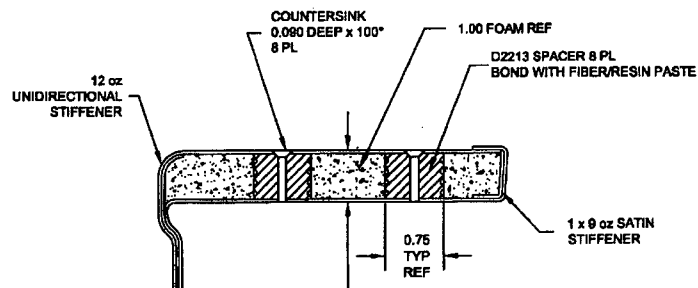
SECTION A-A
TYPICAL FLOOR SECTION

B7-B
B3-B
B6-B



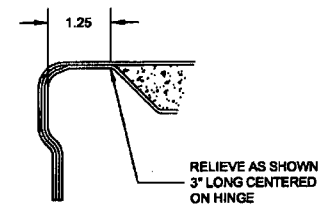
SECTION B-B
SECTION C-C OPPOSITE

B6-B
B6-B
B4-B
B2-B
B7-B
B5-B



SECTION D-D
TYPICAL ROOF SECTION IS SIMILAR
BUT WITHOUT INSERTS

D3-B
D7-B
D8-B



SECTION E-E
2 PLACES PER POD

C2-B
C7-B
B6-B

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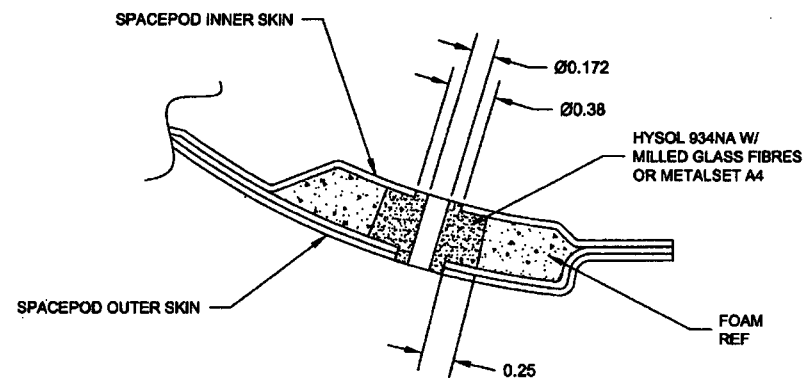
OUTBOARD

INSTALL AKS7-1032-130
INSERTS 28 PL
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)
TO ALIGN WITH HOLES IN D3187-1/-2 FLOORS



SECTION H-H
TYPICAL FLOOR SECTION

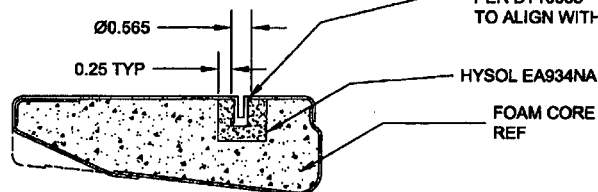
A5-2
A5-3
A5-4
A5-6
B5-6
B5-7



SECTION I-I
SECTION J-J OPPOSITE
4 PLACES PER POD

C5-5
C4-6
C5-7

OUTBOARD



10

INSTALL 80-005-2-10
INSERTS 7 PL
PER DT10068
TO ALIGN WITH HOLES IN D3187-1/-2 FLOORS

SECTION K-K
SECTION L-L OPPOSITE
TYPICAL FLOOR SECTION

B4-2
B5-3
B4-4
B4-5
B4-6
B4-7

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